

Date: Monday, 2/27/2006 4:18:13 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CROSSBOLT SPACER
Job Number : 25977	
Estimate Number : 10993	
P.O. Number : N/A	Part Number : D2579
This Issue : 2/27/2006 S.O. No. : N/A	Drawing Number : D2579 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 25138	Material : N/A
	Due Date : 3/21/2006
Written By : _____	Qty: 550 Um: Each
Checked & Approved By : <u>KJ 06.02.28</u>	
Comment : Est E 02.06.17 Now turned on Cobra NG	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0500W058	6061-T6 Tube .500 x.058W
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Comment: Qty.: 0.3762 f(s)/Unit Total: 188.1075 f(s)

6061-T6 Tube .500 x.058W

Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4)

0.500 Dia x 0.058 Wall

Batch

M100423

M19405

06/04/04

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

Machine as per Folio FA245

06/04/10

550

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/04/10

550

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

BG 06.04.10 550

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

to Barclay

06/04/10

547

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 06/04/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 2/27/2006 4:18:13 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 25977

Part Number: D2579

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*Handwritten:* 06/04/11 (577)

Job Completion



*Handwritten:* 06-04-11

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries


<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>25977</b>
<b>Description:</b> Cross Bolt Spacer	<b>Part Number:</b>	<b>D2579</b>
<b>Inspection Dwg:</b> D2579 <b>Rev:</b> D		<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

## First Article

## Prototype

[illegible]

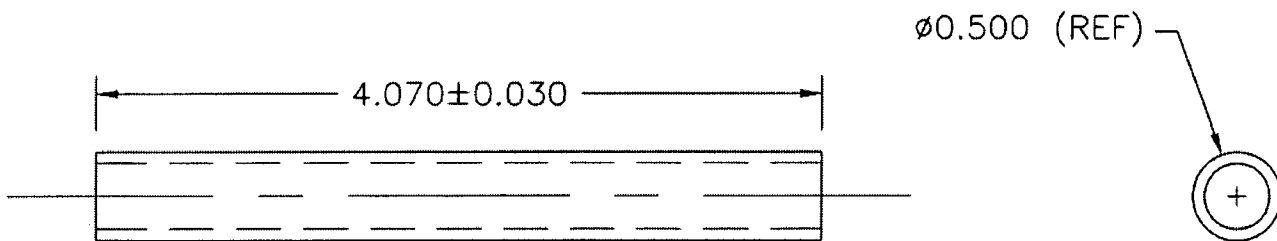
Measured by: 	Audited by: BG	Prototype Approval:	N/A
Date: 06/04/06	Date: 06-04-10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.27	New Issue	KJ/RF	



DESIGN <del>DA</del>	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <del>DA</del>	APPROVED LE	DRAWING NO. D2579	REV. D SHEET 1 OF 1
DATE 99.05.19		TITLE CROSS BOLT SPACER	SCALE 1:1
A	96.09.16	NEW ISSUE	
B	96.12.05	0.065 WALL WAS 0.035 WALL	
C	97.02.21	0.058 WALL WAS 0.065 WALL	
D	99.05.19	4.070 LENGTH WAS 4.100 (TSR A1095)	

RELEASED  
99.05.20 DS



MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)  
0.500 DIA x 0.058 WALL

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25977

